

# Work Order ID 72335

Friday, July 22, 2011 12:32:15 PM



Page 1

Item ID: D350-748-141TRN

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-748-141

F U/R

OK CP 11.09.27

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs on both ends as per Folio FA648  
2-Turn first side as per Folio FA648  
3- File transition lines smooth.

1 Ø  
anam.L 11/08/16

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

1 Ø  
anam.L 11/08/16

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA648  
2- File transition lines smooth  
3-Scribe Part & Batch as per Dwg D350-748-141

1 Ø  
OFB / anam.L 11/08/16

(P/O)

W/O: 12335		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-141TRN PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.08.18	100	O.D. UP TO 0.002" UNDER TOLERANCE ON SIDE. R.L. Program MOD.	CP 11.08.18 Q51042	Acceptable. Within allowable damage clean-up of 0.005"	CP 11/08/22	B.A 11/08/22	CP 11.08.18 Q51042	5 11/08/22

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Large Fab

0.00



Crosstubes

Memo

0.00

Crosstubes

Grind machining marks

11/08/17 1 0

B.A 11/08/22 1 0

JW 11-08-23

W/O:		WORK ORDER CHANGES					
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**Work Order ID 72335**

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Page 3

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Required Date: 7/29/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Outsource process - Heat Treat

0.00



Outsource1

Memo

0.00

Outsource process - Heat Treat

Issue P/O:

14727

Heat Treat to min 180 KSI As per Dwg D350-748-141  
(MIL-T-6736 OR AMS 2759-1C)  
Sand Blast tube after Heat Treat  
Possible Supplier: Vac Aero  
Ensure Certificate of Conformity is attached

C2 11/08/24 (1)

170

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

C4/5/26 C

180

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Sulorbo

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 4

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Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and stock in kanban rack Location: <u>Back Hall</u>								
			am am, l	11/09/26					
200 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/27

MF  
11-09-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, July 22, 2011 12:32:21 PM

Page 1

Work Order ID: 72335

Parent Item: D350-748-141TRN

Parent Item Name: Crosstube Turning Detail



Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec  
IPP Rev B Removed polish 08.04.02 EC verified by : DD  
IPP Rev C Remove LPS-3 08.06.23 EC verified by DD IPP Rev C  
11.02.24 as per dwg rev.F DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6015-125 		Manufactured	No			110	Each	43.0000	1	1			
Crosstube Material													

Location

Loc Qty

Loc Code

HALL

43

61380

43

8 man, l 11/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 72335
<b>Description:</b> Crosstube Assembly (AS350/355 High Fwd)	<b>Part Number:</b> D350-748-141
<b>Inspection Dwg:</b> D350-748-141 <b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	<del>2.240</del>	✓	2.238	Mic.	CNC-04
	2.180	+0.005/-0.000	<del>2.180</del>	✓	2.279	"	"
	2.180	+0.005/-0.000	2.190	✓		"	"
	2.237	+0.005/-0.000	<del>2.237</del>	✓	2.235	"	"
	2.272	+0.005/-0.000	<del>2.272</del>	✓	2.271	"	"
	2.306	+0.005/-0.000	<del>2.306</del>	✓	2.306	"	"
	2.339	+0.005/-0.000	<del>2.339</del>	✓	2.338	"	"
	2.339	+0.005/-0.000	2.346	✓		"	"
	0.062	+/-0.010	.062	✓		vern.	J.F-01
	4.26	+/-0.030	4.289	✓		"	"
	R0.063	+/-0.010	.063	✓		R.G.	Ref.
	R0.50	+/-0.030	R0.500	✓		R.G.	Ref.
	2.240	+0.005/-0.000	2.240	✓		Mic.	CNC-04
	2.180	+0.005/-0.000	2.182	✓		"	"
SIDE B	2.180	+0.005/-0.000	2.184	✓		"	"
	2.237	+0.005/-0.000	2.241	✓		"	"
	2.272	+0.005/-0.000	2.276	✓		"	"
	2.306	+0.005/-0.000	2.307	✓		"	"
	2.339	+0.005/-0.000	2.236	✓		"	"
	2.339	+0.005/-0.000	2.346	✓		"	"
	0.062	+/-0.010	.062	✓		vern.	J.F-01
	4.26	+/-0.030	4.275	✓		"	"
	R0.063	+/-0.010	.063	✓		R.G.	Ref.
	R0.50	+/-0.030	R0.500	✓		"	"
	110.27	+/-0.060	110.26	✓		shape	mmk-02

<b>Measured by:</b> mm L/DK	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 11/08/16	<b>Date:</b> 11/08/12	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

#### GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115  
FINISHED LENGTH = 110.270±0.06
- FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 30.45 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.  
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 72335

UNDER REVIEW

RELEASED  
2011-01-18 D

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C8-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-748-141	REV. F SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
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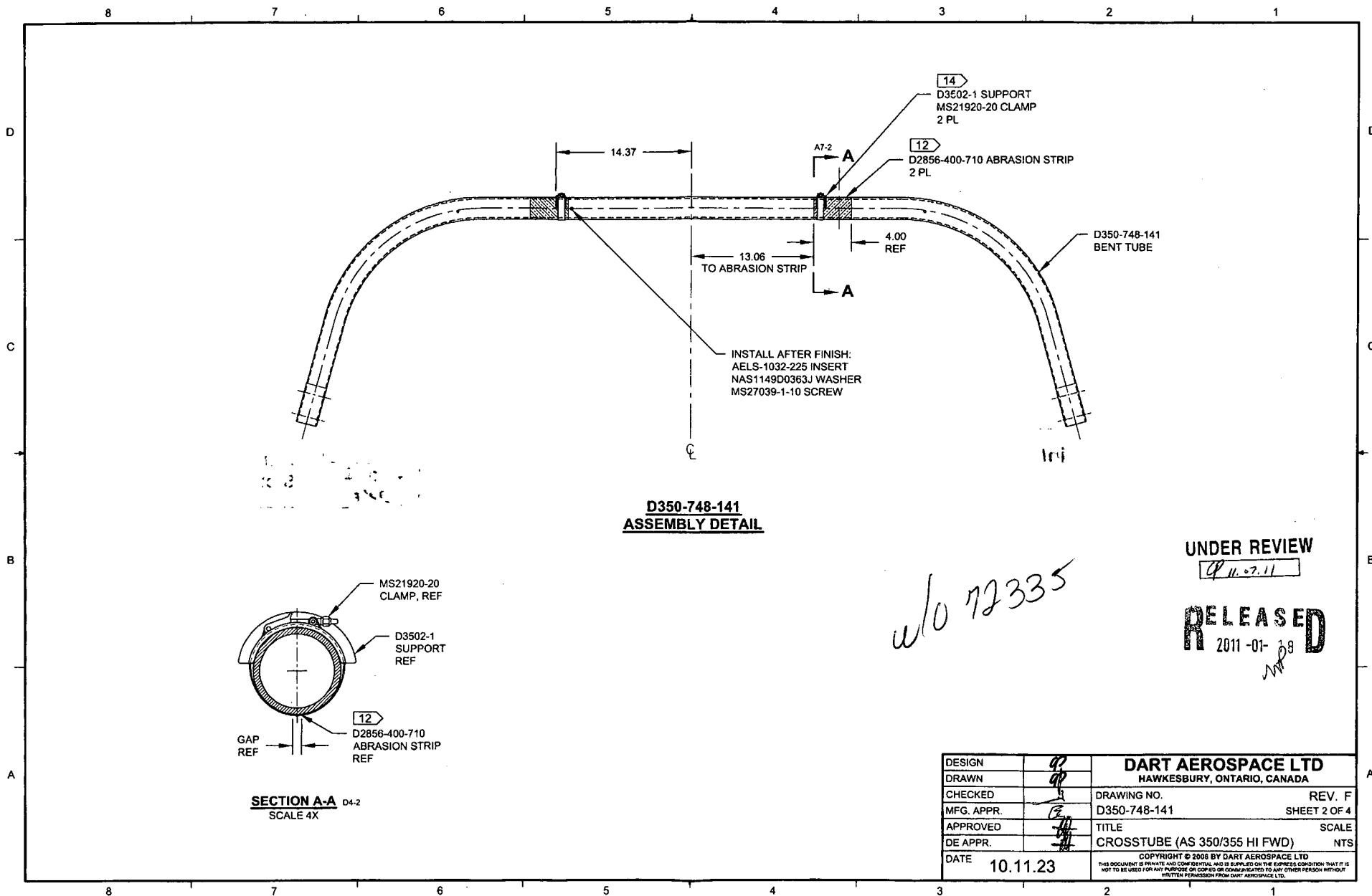
W/O:		WORK ORDER CHANGES					
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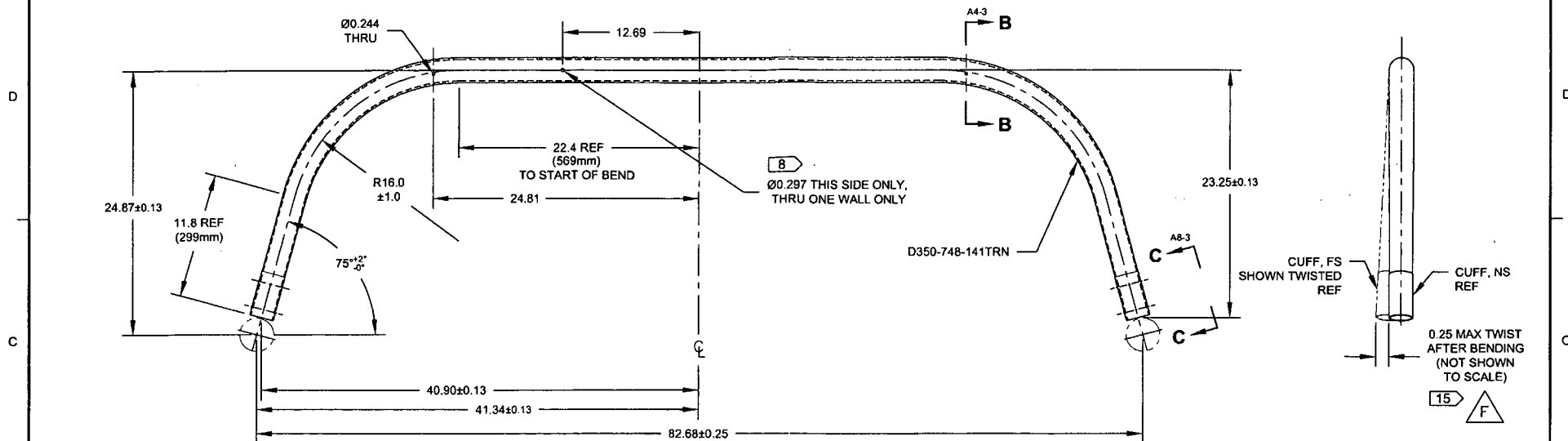
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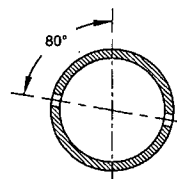
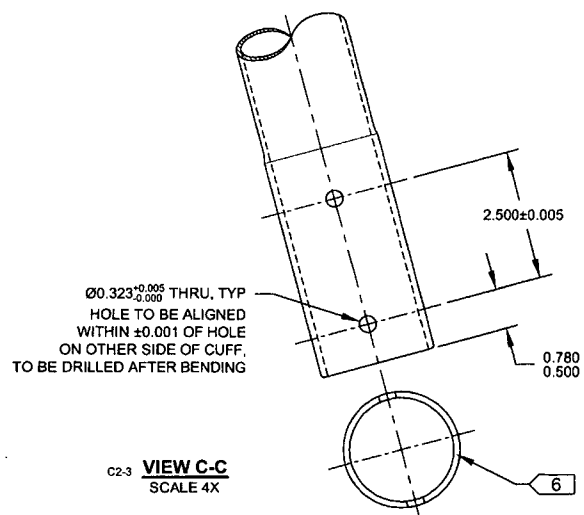
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8 7 6 5 4 3 2 1



**D350-748-141**  
**BENDING AND DRILLING DETAIL** 10



**SECTION B-B** D3-3  
SCALE 4X

*w/ 12335*

UNDER REVIEW

11.27.12

RELEASED  
2011-01-18

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. F
MFG. APPR.	DP	D350-748-141	SHEET 3 OF 4
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

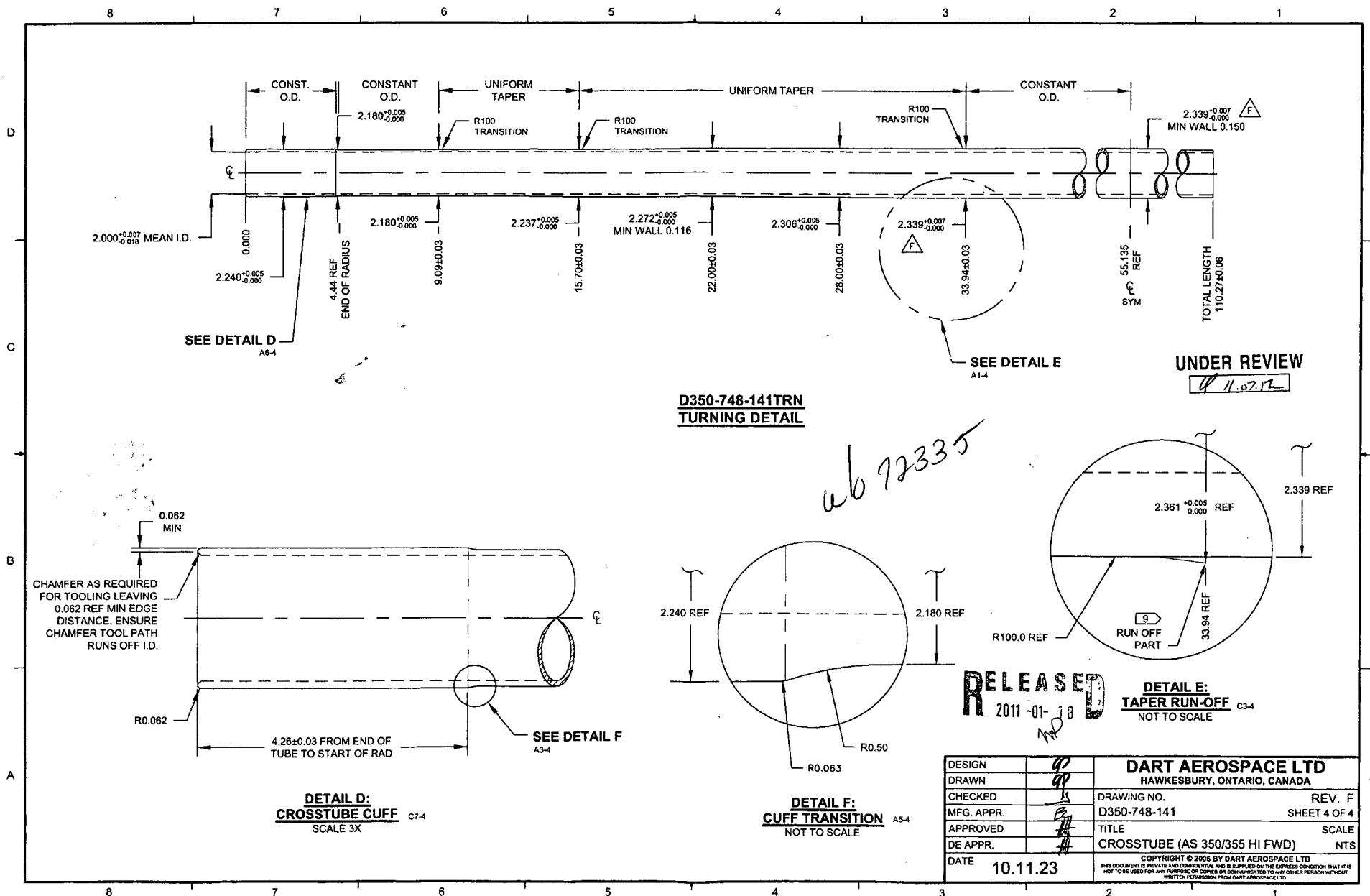
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



VAC AERO  
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 133773-1



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION  
7450 RUE VERITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

09/22/2011

MM / DD / YYYY

PAGE: 1

1DAR01

BILL TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
09/22/2011		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
P014727		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141 CROSS TUBE	EA	12	12	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1E 100% HARDNESS CHECKED AS PER ASTM E-18 40/45 HRC MATERIAL: 4130</p> <p>LINE# 70650, 1 PC LINE# 72812, 1 PC LINE# 70652, 1 PC LINE# 72813, 1 PC LINE# 72334, 1 PC LINE# 72814, 1 PC LINE# 72335, 1 PC LINE# 72815, 1 PC LINE# 72336, 1 PC LINE# 72816, 1 PC LINE# 72337, 1 PC LINE# 72817, 1 PC</p> <p>100% HARDNESS TESTED OK - 12 PG 44/45 HRC 2250/11</p> <p>VALO TEC 450100 - ISO 9001</p>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.



Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

Heat Treating - Welding